

**Work Order ID 64174**

Friday, November 26, 2010 4:14:52 PM



Page 1

Item ID: K642-512

Accept



Setup

Start



Revision ID:

Item Name: saddle kit 642-512

Stop



Start Date: 11/29/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 12/2/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-11-26 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9467	Rev A								
IIN D206-642	Rev N								

100



DOCUMENT CONTROL

DC

Memo

0.00

MF 11 12 03

Document Control

Create White labels per PPP K642-512 CHG004

110



Pick Kit

0.00

Packaging

Packaging

Memo

0.00

11/12/20 03

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

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Work Order ID: 64174



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Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 05.06.07 new issue EC  
IPP Rev.B 05.02.08, Per ECN1080P

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C35A  BOLT X3		Purchased	No			110	Each	97.0000	3	9			

Location	Loc Qty	Loc Code
ST353	97	
111724	1	
112489	16	
114523	30	
116082	50	

m1602  
27  
Cer 12/01 (3)

Location	Loc Qty	Loc Code
ST353	178	
109771	6	
115882	22	
116050	50	
116202	50	
116239	50	

m116202 180  
m116239 90

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00

AN3C41A  
BOLT  
X3

Purchased No 110 Each 103.0000 8 24



C

Location	Loc Qty	Loc Code
FG	4	
103324	4	
ST354	99	
114443	17	
115316	32	
116050	50	

M116050

AN4C6A  
Bolt  
X3

Purchased No 110 Each 429.0000 12 36



C

Location	Loc Qty	Loc Code
FG	4	
103344	4	
ST356	425	
113121	15	
115016	200	
116003	200	
116075	10	

115016

AN5C11A  
Bolt  
X3

Purchased No 110 Each 198.0000 8 24



C 11/2/10 (3)

Location	Loc Qty	Loc Code
FG	3	
104817	3	
ST338	195	
114443	14	
114455	70	
114523	61	
116075	50	

+13

M114523

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00

AN5C12A



BOLT

Purchased No 110 Each 136.0000



12

*C*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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FG	2	
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18918	2	
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ST338	134	
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113121	42	
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116075	92	
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AN5C13A



BOLT

Purchased No 110 Each 154.0000



12

*M116075*

*C*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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FG	2	
----	---	--

18918	2	
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ST338	152	
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113121	2	
--------	---	--

114615	50	
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116075	100	
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AN5C15A



Bolt

Purchased No 110 Each 74.0000



3

*C, 10/12/10*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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ST339	74	
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111819	74	
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*M111819*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 64174



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Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00

AN5C32A



X3

Purchased	No	110	Each	76.0000	2	6
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<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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FG	4	
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18918	4	
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ST340	72	
-------	----	--

111808	22	
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113164	50	
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111808

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AN5C34A



X3

Purchased	No	110	Each	90.0000	2	6
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<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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FG	2	
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18918	2	
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ST340	88	
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111648	28	
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112454	60	
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111648

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AN5C35A



X3

Purchased	No	110	Each	86.0000	1	3
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<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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ST340	86	
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108084	40	
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108407	46	
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108084

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 11/29/2010

Required Date: 12/2/2010

AN960C101

NAS1149C0332

Purchased

No

110

Each

25.0000

24

72

washer



AN960C416L

WAS1149C0332

Purchased

No

Location

ST245

Loc Qty

25

Loc Code



M115832



WASHER

X3

AN960C516L

NAS1149C0532

Purchased

No

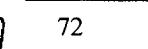
Location

ST346

Loc Qty

19

Loc Code



M11474233X

WASHER

X3

D206-648-013

Manufactured

No

Location

ST347

Loc Qty

6

Loc Code



M115631

GHW Modification

X3

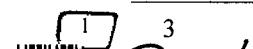
Location

111916

Loc Qty

6

Loc Code



M11628924

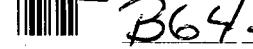
Location

FG120

Loc Qty

10

Loc Code



B64/309 10/12/95

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 64174



10

Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00

D2652



Bushing

D2712



Set Screw

D2932-2



Saddle RH Out, 206

D2933-2



Saddle RH In, 206

Manufactured	No	110	Each	79.0000
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16

48

63991

11/14/10

Location	Loc Qty	Loc Code
FG	44	
31985	44	
ST020	35	
61645	1	
63311	34	

Manufactured	No	110	Each	338.0000
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10

30

le

Location	Loc Qty	Loc Code
FG	50	
29962	50	
ST022	288	
61331	288	

Manufactured	No	110	Each	15.0000
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1

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61331

le

Location	Loc Qty	Loc Code
ST421	1	
62637	1	
ST428	8	
52586	6	
60253	2	
ST428A	6	
62080	6	

Manufactured	No	110	Each	0.0000
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1

3

52586

1

3

B62081 10/10/2010 34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Picklist Print

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Work Order ID: 64174



10

Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00

D2934

Manufactured No

110 Each 45.0000

2 6



Saddle Spacer

X3

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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FG	6	
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31929	6	
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ST028	39	
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63559	39	
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	39	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 64174



10

Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00

D3396-3

Manufactured No 110 Each 53.0000

2 6



Spacer

Location	Loc Qty	Loc Code
FG	10	
26772	10	
ST055	43	
58680	3	
63557	40	

103587

D3407-043

Manufactured No 110 Each 4.0000

1 3



Tow Ring

Location	Loc Qty	Loc Code
ST420	3	
62627	3	
ST464	1	
50387	1	

B63S67 10/12/2010

D3456-17

Manufactured No 110 Each 24.0000

1 3 ✓



Washer

Location	Loc Qty	Loc Code
ST058	24	
63239	24	

63239

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: K642-512



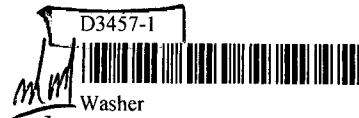
Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00



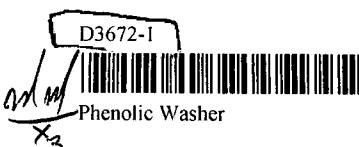
Manufactured	No	110	Each	39.0000	2	6
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*Le*

Location	Loc Qty	Loc Code
FG	10	
32409	10	

ST059	29	
45913	1	
62691	28	

62691

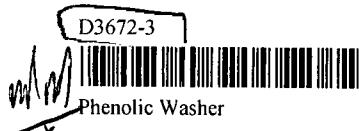


Manufactured	No	110	Each	653.0000	24	72
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*B*

Location	Loc Qty	Loc Code
ST077	653	
42329	10	
52505	643	

52505



Manufactured	No	110	Each	327.0000	24	72
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*10/11/30*

Location	Loc Qty	Loc Code
ST077	327	
57704	327	

57704



Manufactured	No	110	Each	388.0000	24	72
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*B64175 10/11/58*

Location	Loc Qty	Loc Code
ST077	388	
53237	388	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: K642-512



Parent Item Name: saddle kit 642-512

Start Date: 11/29/2010

Required Date: 12/2/2010

Start Qty: 3.00

Required Qty: 3.00

MS21043-3



Nut

X3

Purchased	No	110	Each	2,116.000	20	60
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*C*

Location	Loc Qty	Loc Code
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FG	76	
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103691	76	
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ST301	2040	
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112314	2040	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

RE: Date & initial all entries

## 4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

Item	Qty -511	Qty -512	Qty -541	Qty -547	Qty -013	Part Number	Description
	X					D206-642-511	SKIDTUBE INSTALLATION, LH
		X				D206-642-512	SKIDTUBE INSTALLATION, RH
1	1	X				D206-642-541	SKIDTUBE
			X			D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
1	1				X	D206-648-013	GROUND HANDLING KIT
						D3274-041	SKIDTUBE ASSEMBLY
3			1			D2646	* AFT CAP <sup>(1)</sup>
4			2			AN3C4A	* BOLT <sup>(1)</sup>
5A			2			AN960C10L	* WASHER <sup>(1)</sup>
5B			2			D3672-1	* WASHER (REPLACES NAS1515H3L) <sup>(1)</sup>
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3C41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21043-3	NUT
12B	16	16				D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4				AN5C11A (or AN5C12A)	* BOLT <sup>(2)</sup>
14	4	4				AN5C11A (or AN5C13A)	* BOLT <sup>(2)</sup>
15A	8	8				AN960C516L	WASHER
15B	8	8				D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12				AN4C6A	BOLT
17A	24	24				D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24				AN960C416L	WASHER
18	12	12				MS21043-4	NUT
20A			9	9		D3537-1	* WEARPAD <sup>(1)</sup> (REPLACES D2648-3)
21A			1	1		D3537-3	* WEARPAD <sup>(1)</sup> (REPLACES D3429-1)
22A			1	1		D3535-15	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-15)
22B			1	1		D3536-15	* GASKET <sup>(1)</sup>
23A			1	1		D3535-23	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-23)
23B			1	1		D3536-23	* GASKET <sup>(1)</sup>
24A			1	1		D3535-39	* WEARSHOE <sup>(1)</sup> (REPLACES D3287-1)
24B			1	1		D3536-39	* GASKET <sup>(1)</sup>
25A			1	1		D3535-35	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-35)
25B			1	1		D3536-35	* GASKET <sup>(1)</sup>
26A			78	78		AN3C4A	* BOLT <sup>(1)</sup>
26B			78	78		AN960C10L	* WASHER <sup>(1)</sup>
26C			78			ALS7-1032-130	* INSERT <sup>(1)</sup> (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34			1			AN4C5A	BOLT
35			1			AN960C416	WASHER
36			1			D3413-1	RING
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER

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ITEM	QTY -511	QTY -512	QTY -541	QTY -547	QTY -013	PART NUMBER	DESCRIPTION
40					2	D3414-041	LUG ASSEMBLY (GHW)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER
50	9	9				AN3C36A	BOLT
51	3	3				AN3C35A	BOLT
52	24	24				AN960C10L	WASHER
53	24	24				D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12				MS21043-3	NUT
55	2	2				D3396-3	SPACER
56A	1	1				AN5C35A	BOLT
56B	1	1				AN5C15A	BOLT
60	2	2				AN5C32A	BOLT
61	2	2				AN5C34A	BOLT
62	4	4				MS21043-5	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 ASSEMBLY ABOVE  
 (2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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